

Date: Thursday, 7/13/2006 3:24:30 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 27888
 Estimate Number : 10531
 P.O. Number : NIA Part Number : D2572
 This Issue : 7/13/2006 S.O. No. : NIA Drawing Number : D2572 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 27762 Material : NIA
 Written By : SEE COMMENT BELOW Due Date : 8/9/2006 Qty: 16 Um: Each
 Checked & Approved By : 06.07.13
 Comment : Est: 1 0240.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: _____

325850 x 16

3.6 / 16

06107121

16

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 327282 Double check by: J-L

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove shap edges.

3.6 / 16

06107121

16

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

3.6 / 16

06107121

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/13/2006 3:24:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 27888

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.6/EP 06/07/21

16

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

9mL 06/07/24

16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DL 06/07/24

16

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/25

(16)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

RV 06/27/26 (16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SSI 479

LB 06/07/26 (16)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/07/27 (16)

Job Completion



06.07.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27888
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.744	1.748	1.747	1.746		
C	3.495	3.505		3.501	3.498	3.497	3.498		
D	1.745	1.755		1.744	1.744	1.744	1.747		
E	7.990	8.010		8.000	7.994	7.998	7.994		
F	0.490	0.510		0.501	0.501	0.497	0.498		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.501	0.494	0.497	0.498		
J	1.174	1.184		1.180	1.180	1.178	1.180		
K	0.558	0.578		0.568	0.567	0.566	0.568		
L	1.174	1.184		1.180	1.180	1.178	1.179		
M	1.490	1.500		1.494	1.498	1.497	1.498		
N	2.495	2.505		2.494	2.498	2.498	2.499		
O	3.869	3.879		3.870	3.871	3.871	3.870		
P	0.115	0.135		0.121	0.121	0.121	0.122		
Q	0.115	0.135		0.134	0.133	0.132	0.134		
R	0.240	0.260		0.245	0.246	0.247	0.246		
S	0.115	0.135		0.126	0.126	0.125	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.962	2.964	2.963		
V	0.230	0.250		0.236	0.236	0.235	0.234		
W	0.115	0.135		0.126	0.125	0.124	0.123		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.364	0.364	0.364	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.621	0.622	0.624	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.244	0.244	0.241		
AE	1.375	1.395		1.385	1.384	1.384	1.388		
AF	0.115	0.135		0.125	0.124	0.124	0.123		
AG	0.240	0.280		0.261	0.261	0.262	0.261		
AH	0.240	0.260		0.255	0.255	0.249	0.248		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: S.G.	Audited by: Jm
Date: 06/07/17	Date: 06/07/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27888
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

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				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.747	1.749	1.746		
C	3.495	3.505		3.496	3.499	3.498	3.497		
D	1.745	1.755		1.745	1.747	1.749	1.746		
E	7.990	8.010		7.998	8.000	8.001	8.001		
F	0.490	0.510		0.496	0.496	0.494	0.497		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.497	0.494	0.492	0.490		
J	1.174	1.184		1.174	1.178	1.176	1.179		
K	0.558	0.578		0.563	0.562	0.560	0.562		
L	1.174	1.184		1.174	1.178	1.176	1.175		
M	1.490	1.500		1.492	1.493	1.495	1.493		
N	2.495	2.505		2.497	2.497	2.498	2.499		
O	3.869	3.879		3.872	3.873	3.872	3.870		
P	0.115	0.135		0.127	0.125	0.123	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.252	0.251		
S	0.115	0.135		0.123	0.124	0.124	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.239	0.239	0.242	0.236		
W	0.115	0.135		0.132	0.130	0.131	0.131		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.362	0.360	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.620	0.622	0.619	0.621		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.242	0.244	0.243		
AE	1.375	1.395		1.386	1.388	1.379	1.384		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.250	0.249	0.250		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	3.61 CP
Date:	06/07/19

Audited by:	JK
Date:	06/07/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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Inspection Dwg: D2572 Rev. E		Page 1 of 1

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Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
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B	1.745	1.755		1.745	1.747	1.747	1.746		
C	3.495	3.505		3.499	3.499	3.499	3.498		
D	1.745	1.755		1.745	1.747	1.747	1.746		
E	7.990	8.010		8.000	8.002	8.000	8.000		
F	0.490	0.510		0.497	0.498	0.499	0.497		
G	0.257	0.262	DT8683	0.257	0.259	0.259	0.255		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.496	0.497	0.498		
J	1.174	1.184		1.174	1.178	1.179	1.180		
K	0.558	0.578		0.563	0.560	0.561	0.560		
L	1.174	1.184		1.174	1.178	1.179	1.180		
M	1.490	1.500		1.491	1.494	1.494	1.496		
N	2.495	2.505		2.498	2.498	2.497	2.497		
O	3.869	3.879		3.872	3.873	3.873	3.874		
P	0.115	0.135		0.123	0.122	0.121	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.251	0.250	0.249		
S	0.115	0.135		0.123	0.126	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.243	0.244	0.243		
W	0.115	0.135		0.127	0.128	0.127	0.126		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.369	0.369	0.368		
AA	0.470	0.530		0.520	0.520	0.520	0.520		
AB	0.615	0.635		0.625	0.623	0.622	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.244	0.241	0.241		
AE	1.375	1.395		1.384	1.382	1.383	1.384		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.246	0.250	0.244	0.249		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP/JS/G
Date:	06/07/20

Audited by:	JML
Date:	06/07/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27888
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B	1.745	1.755		1.747	1.748	1.747	1.747		
C	3.495	3.505		3.498	3.498	3.497	3.499		
D	1.745	1.755		1.749	1.749	1.748	1.748		
E	7.990	8.010		8.000	8.001	8.001	7.999		
F	0.490	0.510		0.499	0.498	0.499	0.498		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.498	0.497	0.496	0.499		
J	1.174	1.184		1.180	1.179	1.178	1.179		
K	0.558	0.578		0.568	0.567	0.568	0.566		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.499	1.498	1.499	1.499		
N	2.495	2.505		2.499	2.498	2.497	2.499		
O	3.869	3.879		3.872	3.871	3.872	3.871		
P	0.115	0.135		0.122	0.124	0.124	0.123		
Q	0.115	0.135		0.126	0.127	0.126	0.127		
R	0.240	0.260		0.249	0.248	0.247	0.246		
S	0.115	0.135		0.130	0.129	0.129	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.962	2.964	2.961		
V	0.230	0.250		0.240	0.239	0.232	0.232		
W	0.115	0.135		0.124	0.123	0.122	0.122		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.362	0.365	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.625	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.258	0.257	0.257	0.256		
AE	1.375	1.395		1.384	1.386	1.385	1.388		
AF	0.115	0.135		0.134	0.134	0.134	0.133		
AG	0.240	0.280		0.261	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.248	0.247	0.246		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

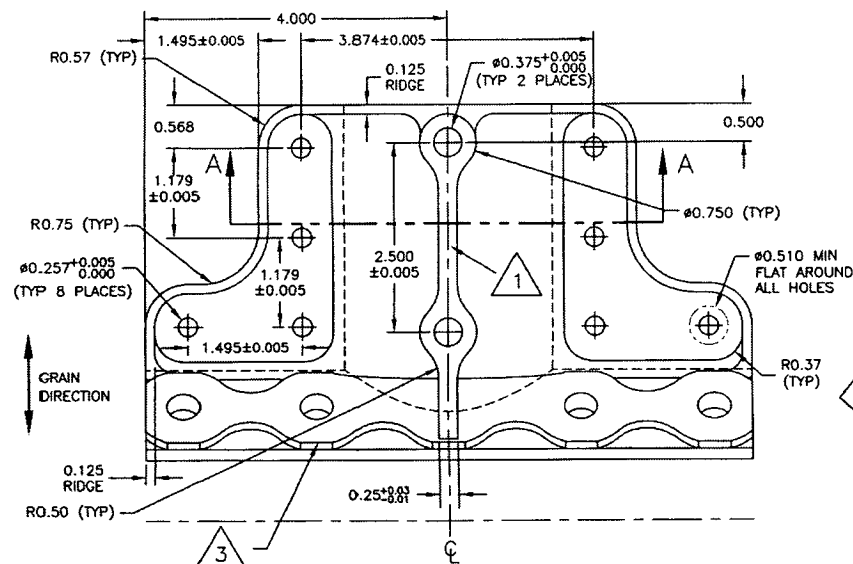
Measured by:	S.G
Date:	06/07/21

Audited by:	mf
Date:	06/07/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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RELEASED

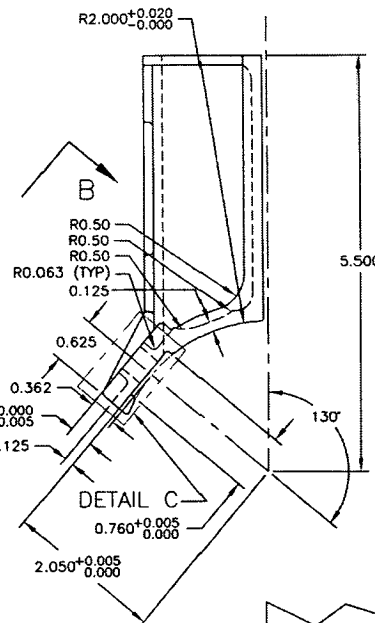
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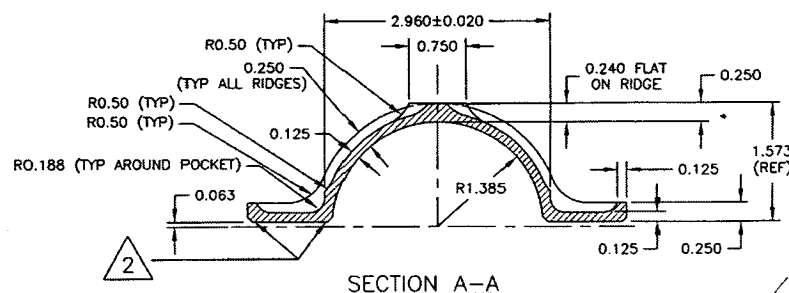
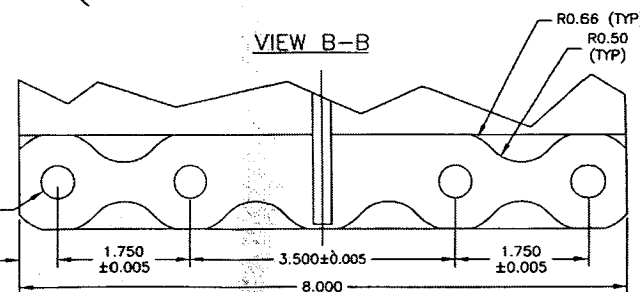
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

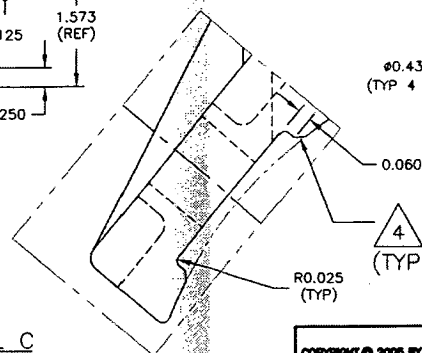
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



VIEW B-B



SECTION A-A



DETAIL C
SCALE 2:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27888

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE
		INNER FWD SADDLE
		REV. E
		SHEET 1 OF 1
		SCALE
		2:3

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